

AKROMID®

S3 GF 15 5 black (6062)

PA610 GF15

AKROMID® S3 GF 15 5 black (6062) is a 15% glass fibre reinforced, high temperature stabilised polyamide 6.10 with average stiffness and strength and lower moisture absorption and high chemical resistance.

Properties

Modulus

5.500 MPa

Strength

120 MPa

Impact

65 kJ/m²

Sustainability

Biobased carbon content

59 %

Mechanical Properties

Tensile modulus

ISO 527-2

1 mm/min | d.a.m.

5500 MPa

Tensile stress at break

ISO 527-2

5 mm/min | d.a.m.

120 MPa

Tensile strain at break

ISO 527-2

5 mm/min | d.a.m.

4 %

Flexural modulus

ISO 178

2 mm/min | d.a.m.

4800 MPa

Flexural strength

ISO 178

2 mm/min | d.a.m.

180 MPa

Charpy impact strength

ISO 179-1/1eU

23°C | d.a.m.

65 kJ/m²

Charpy notched impact strength

ISO 179-1/1eA

23°C | d.a.m.

6 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A ISO 75	1,8 MPa	200 °C
Temperature of deflection under load HDT/C ISO 75	8 MPa	75 °C
Melting temperature ISO 11357-3	DSC, 10K/min	220 °C

Flammability

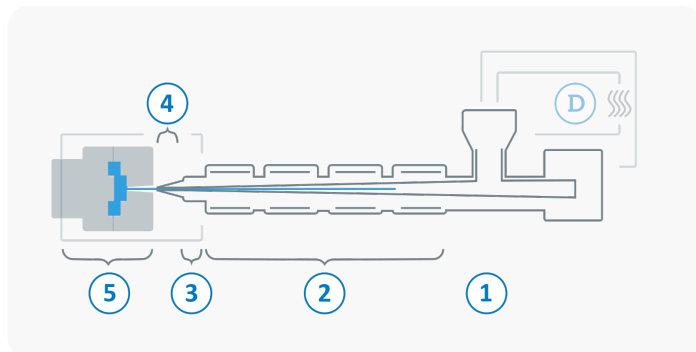
Flammability UL 94	0,8 mm Wall thickness 1,6 mm Wall thickness	HB Class HB Class
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

Density ISO 1183	23°C	1,18 g/cm ³
Humidity absorption ISO 1110	70°C, 62% r.H.	1,4 - 1,6 %
Molding shrinkage ISO 294-4	flow transverse	0,4 - 0,6 % 0,9 - 1,1 %

Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	0 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	240 - 290 °C
3	Nozzle temperature	240 - 300 °C
4	Melt temperature	270 - 290 °C
5	Mold temperature	80 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	50 - 150 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min